

Date: Wednesday, 5/16/2007 1:30:10 PM
User: Kim Johnston

Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, RH
Job Number : 32392A
Estimate Number : 11703
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 32250A
Written By :
Checked & Approved By :
Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Part Number : D2724042
Drawing Number : D2724 REVC
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/12/2007 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description
1 D2622-120C Extrusion

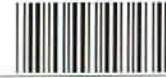
Batch:

B31984

Check Material for any Dents or Defects

FF 07-05-31

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

R.M. 07-05-31

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description
2 D2734 End Cap

Batch

B29340

FF 07-05-31

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-1 Plate

Batch

B31073

FF 07-05-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:30:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

332481=6

331074=2

J.E. 07.05.31

4/2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102756

M103317

Grind end cap welds flush

a.m 07/06/04

(4)

J.E. 07.06.04

J.E. 07.06.04

J.E.

4/2

4/2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RH

07/06/05

(4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-06-05 (4)

RH

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 07.06.07

4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

207-06-07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

J.E. 07.06.11

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:30:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: M102756

Grind end plate flush.

ME 07.16.12

1.E-01-06-11 4
4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/13 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070613 (RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(4X)

Touch up Alodine

M-L 07/06/16

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

PTD

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

20713 (0)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

M104733

07/07/16 (1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/07/16 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/15	5	split to send 1 to outside supplier for priority	u	07/06/15	1	u	1/20/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/07/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 32392 6/7/24 (2)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/27/24

Job Completion



u 6-27-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

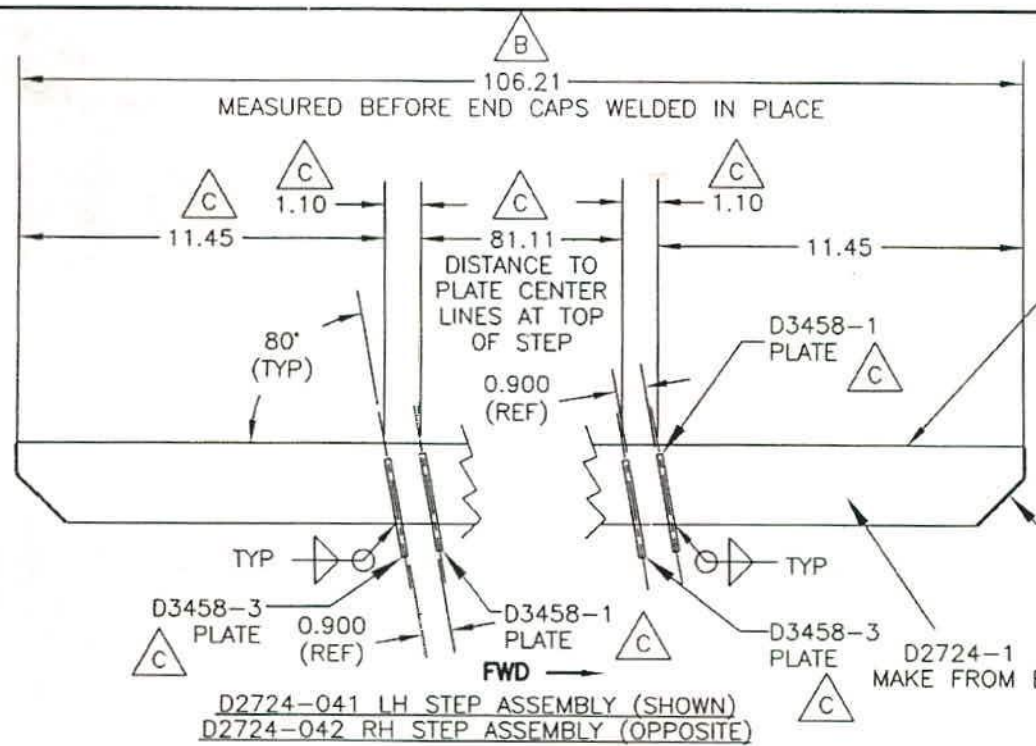
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NOTE: Date & initial all entries

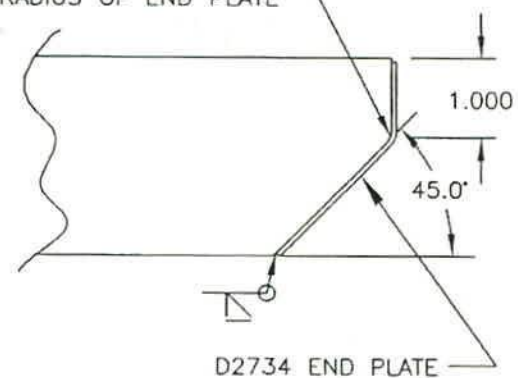
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32392A

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
			TITLE	206L/407 STEP ASSEMBLY
			SCALE	NTS
			SHEET 1 OF 1	REV. C

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